

Work Order ID 73452

Thursday, September 01, 2011 7:32:15 AM

Page 1

Item ID: D3294-1

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 8/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CZDate: 11/09/01

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	Rev C								

100



Waterjet

FLOW CNC Waterjet

2024 . 080

Memo

0.00

B11-9-24

1-Cut as per Dwg D3294

CUt File D3294-3

Dwg Rev: EProg Rev: E

*grain direction on a 45 deg as per dwg**

2-Deburr if necessary

HB11-9-26

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

0.00

0.00

0.00

0.00

130



Brake NC

Memo

Brake NC

Memo

S u/o 127

(X)

140



QC

QC5- Inspect part completeness to step on W/O

Memo

SB u/o 127

(8)

Quality Control

S u/o 127

(X)

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Chemical Conversion Coat per QSI005 4.1

0.00

8 BL 11-9-28

HandFinish

Memo

0.00

Hand Finishing

160



QC3- Inspect Part Finish

0.00

8x M 110912d
count

QC

Memo

0.00

Quality Control

170



0.00

Small Fab

Memo

0.00

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Sulor/29

(Y)

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

W115128

Memo

3:45

Start Time:

320° F

Oven Temperature:

Finish Time:

4:15

8x6ml 11/04/29

200

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

8 8L 11-9-29.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: 212

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CAC/EPB 10/8

10/10/13

*MF
10-09-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, September 01, 2011 7:32:12 AM

Work Order ID: 73452



Parent Item: D3294-1



Parent Item Name: Bracket

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:IPP A 04.08.24 New issue KJ/JLM

IPP Rev:B Now On Waterjet 07-03-26 JLM

IPP Rev:C 08-07-16 Redesign part DD verified by:EC

IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	197.3000	1.8	11.36842		i2	

2024-T3 .080 sheet

Location Loc Qty Loc Code

MAT022	197.3	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	115.2	

B11-9-26

(8)

D3294-5



Manufactured

No

170

Each

17.0000



1

6/11/09/29

Doubler

Location Loc Qty Loc Code

GA	17	
68359	4	
69525	13	

9/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, September 01, 2011 7:32:12 AM

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Parent Item: D3294-1



Parent Item Name: Bracket

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-5



Purchased

No

170

Each

3,074.000

15

90



JBu/09/29

Rivet, Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	3074	
116893	139	
118405	2935	120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73452
Description: Bracket Assembly	Part Number:	D3294-1
Inspection Dwg: D3294 Rev: C		Page 1 of 1

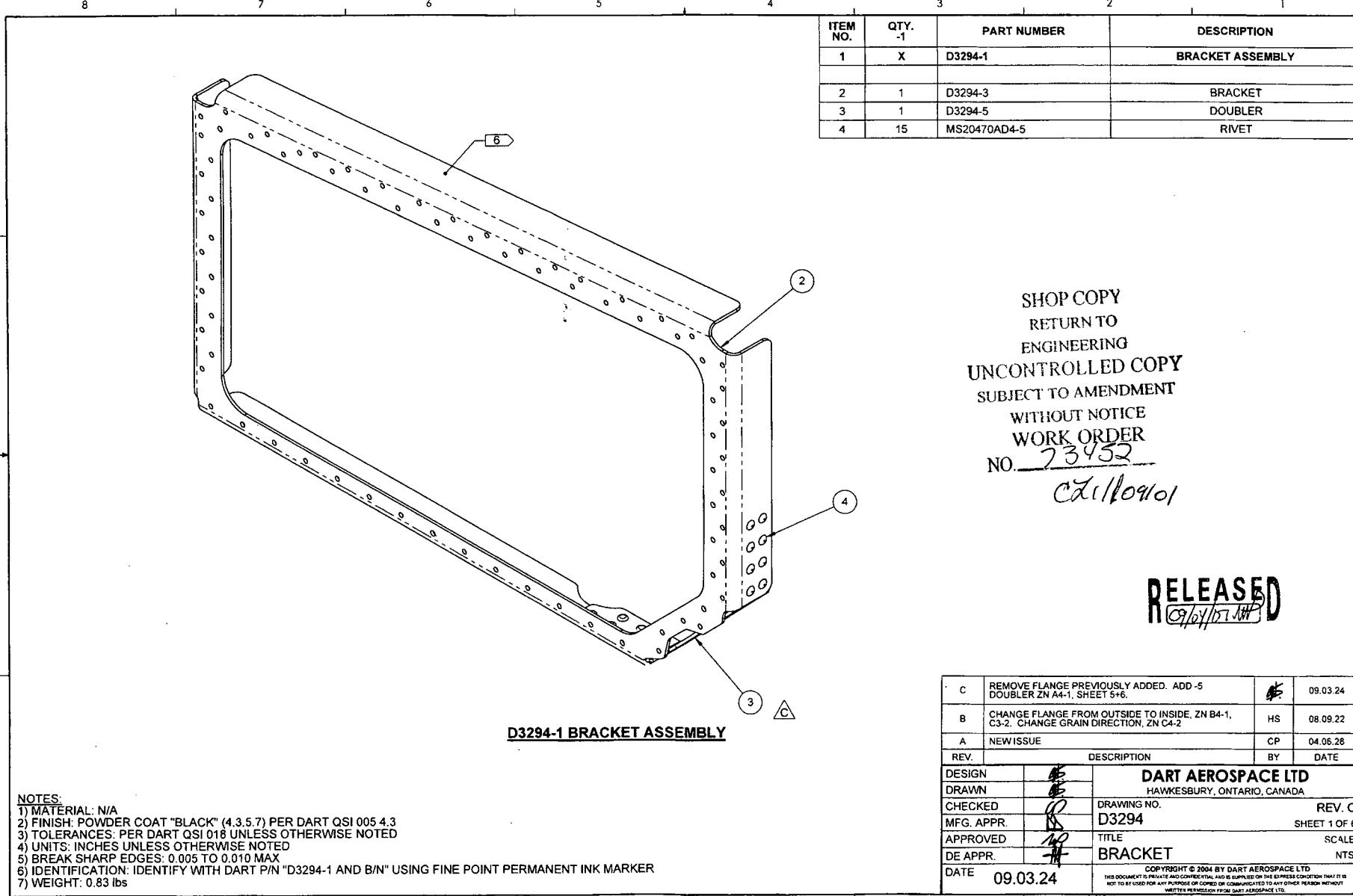
FIRST ARTICLE INSPECTION CHECKLIST

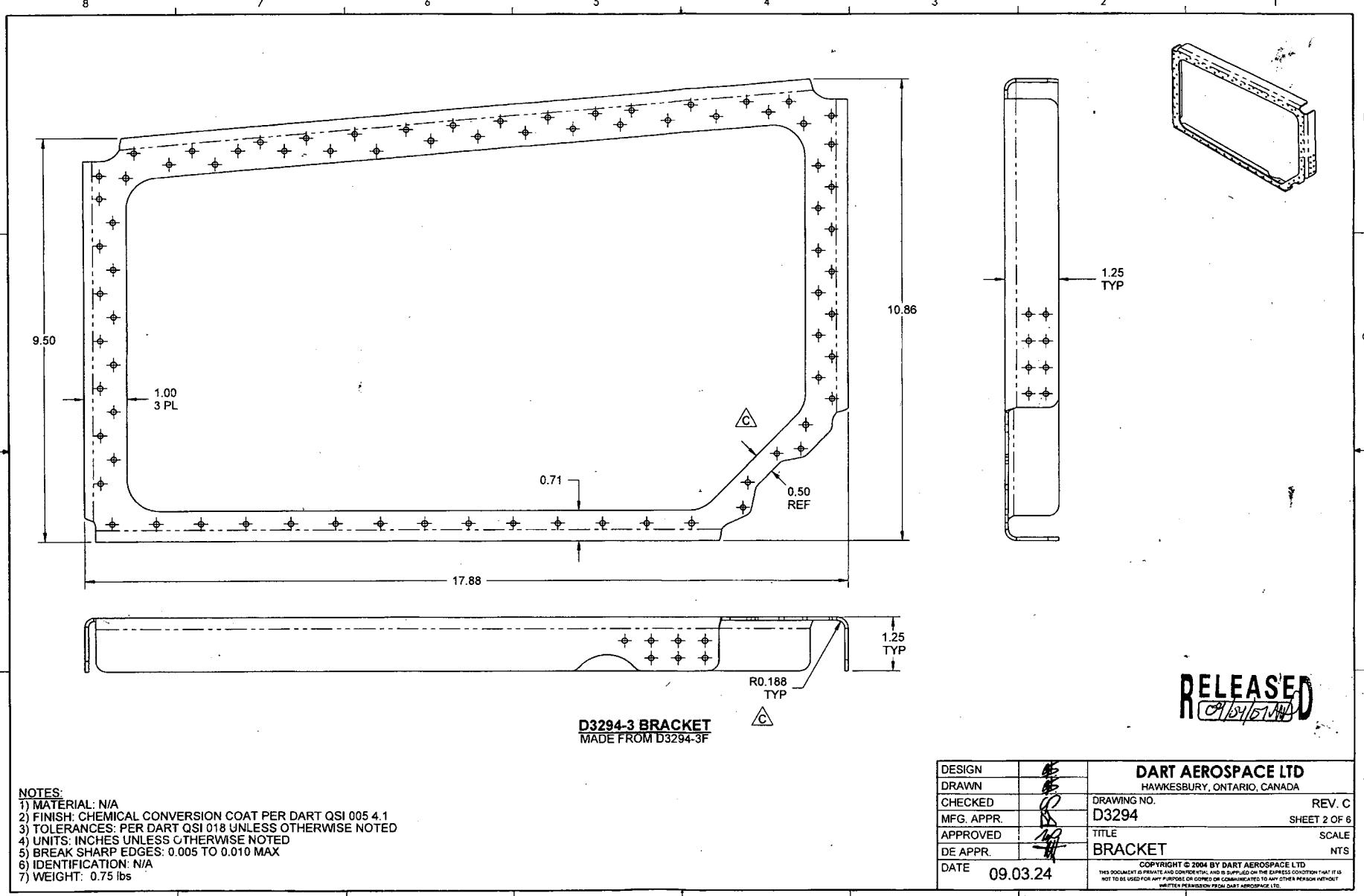
First Article Prototype

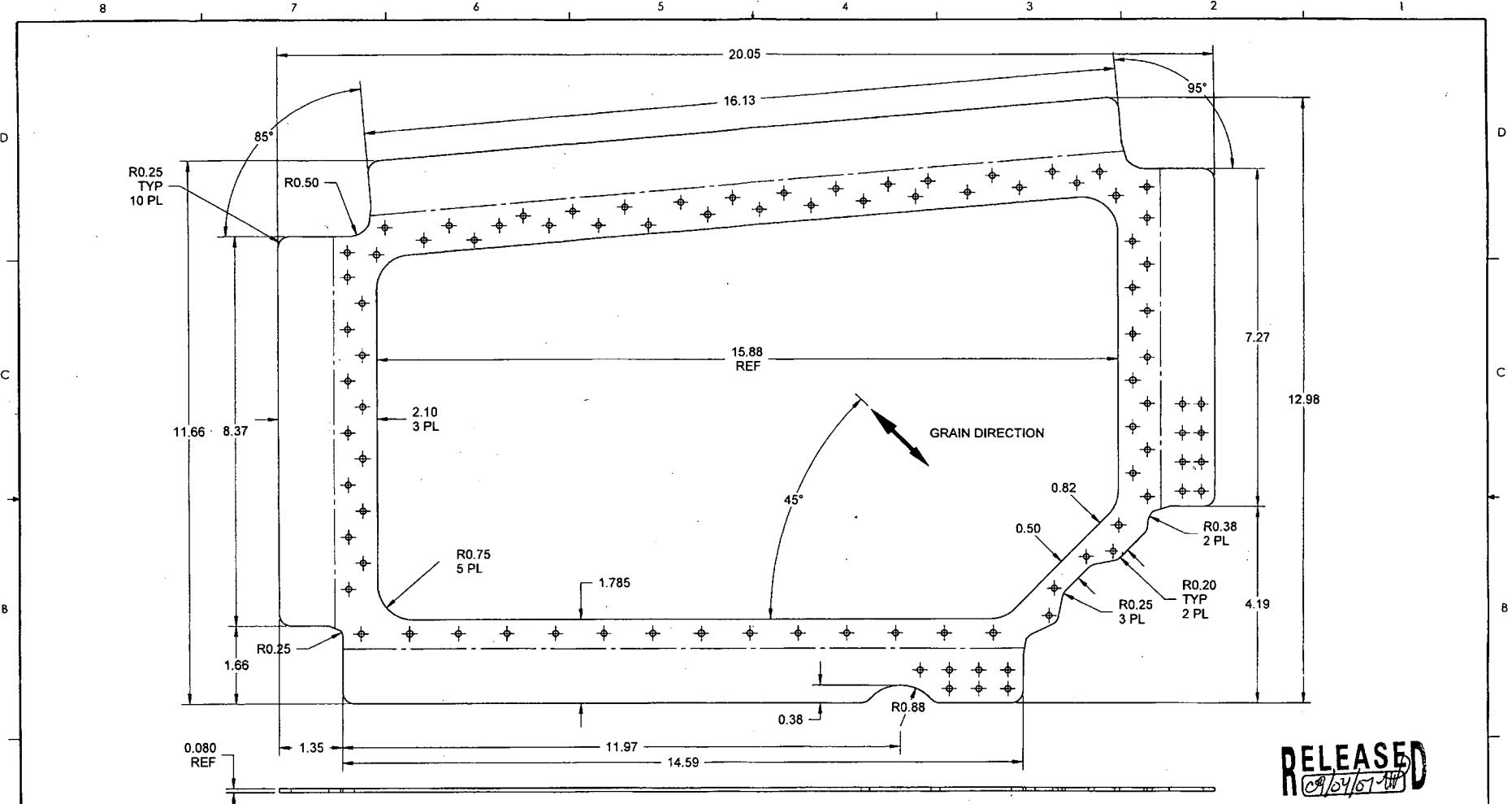
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	✓		V	HB02
Ø0.141	+0.005/-0.001	.142	✓		V	
6.708	+/-0.010	6.711	✓		V	
1.118	+/-0.010	1.117	✓		V	
5.590	+/-0.010	5.591	✓		V	
1.118	+/-0.010	1.118	✓		V	
13.563	+/-0.010	13.563	✓		T	(HB01)
1.043	+/-0.010	1.041	✓		V	
0.625	+/-0.010	.624	✓		V	
0.325	+/-0.010	.323	✓		V	
0.300	+/-0.010	.300	✓		V	
0.400	+/-0.010	.401	✓		V	
6.000	+/-0.010	6.001	✓		V	
1.000	+/-0.010	.998	✓		V	
17.124	+/-0.010	17.124	✓		T	
16.13	+/-0.030	16.13	✓		T	
7.27	+/-0.030	7.274	✓		V	
11.97	+/-0.030	11.97	✓		T	
8.37	+/-0.030	8.370	✓		PROT02	
20.05	+/-0.030	20.05	✓		T	
12.98	+/-0.030	12.98	✓		T	
14.59	+/-0.030	14.59	✓		T	
11.66	+/-0.030	11.66	✓		T	
0.080	+/-0.010	.079	✓		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-9-26	Date:	11-10-23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	M







D3294-3F BRACKET FLAT PATTERN

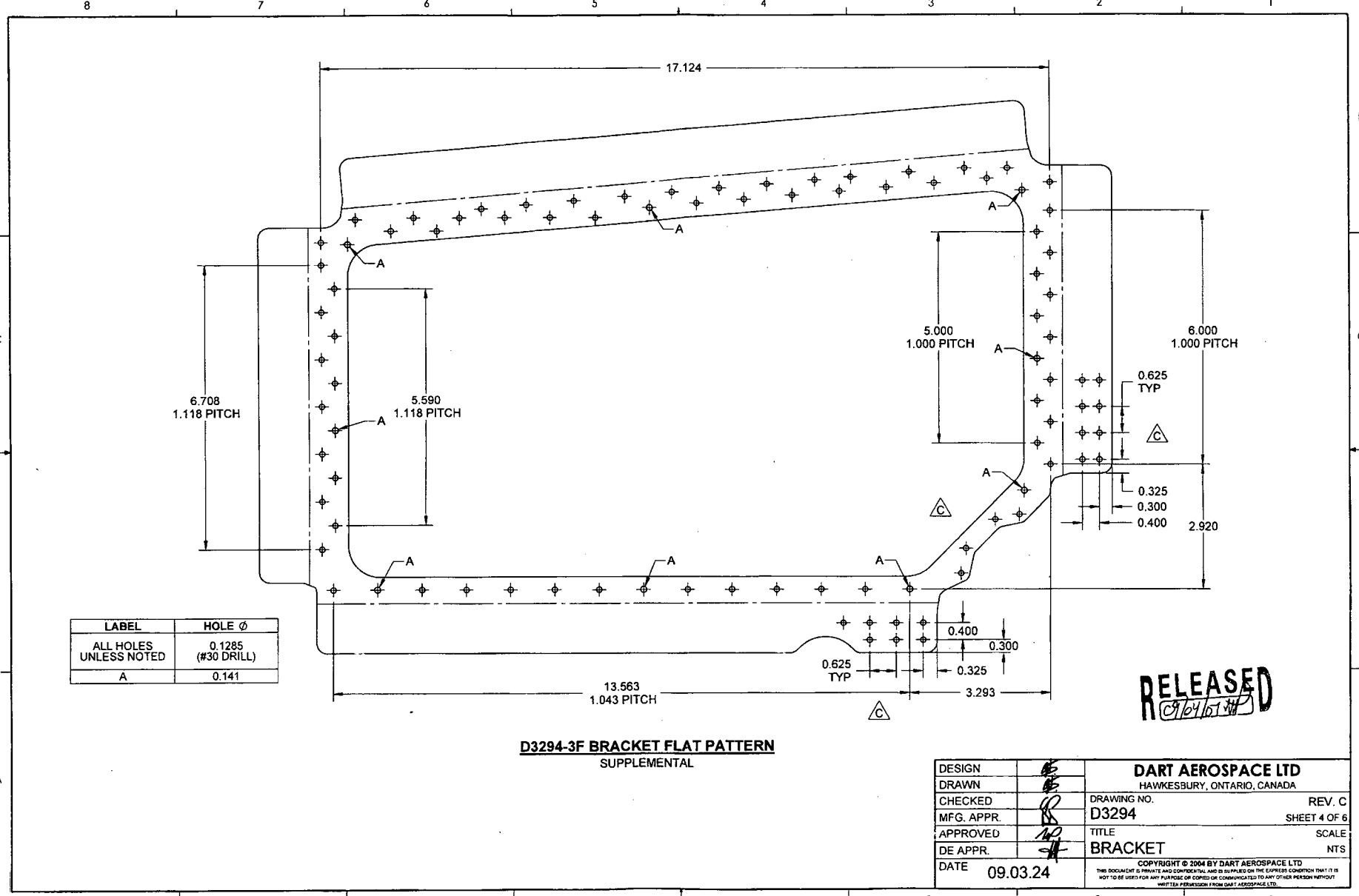
A NOTES

- NOTES:**

 - 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 lbs

DESIGN	<u>5</u>	DART AEROSPACE LTD		
DRAWN	<u>5</u>	HAWKSLEY, ONTARIO, CANADA		
CHECKED	<u>R</u>	DRAWING NO.	REV. C	
MFG. APPR.	<u>R</u>	D3294	SHEET 3 OF 6	
APPROVED	<u>W</u>	TITLE	SCALE	
DE APPR.	<u>W</u>	BRACKET	NTS	
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DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RR</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BB</i>	D3294	SHEET 4 OF 6
APPROVED	<i>BB</i>	TITLE	SCALE
DE APPR.	<i>BB</i>	BRACKET	NTS
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